



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2348

Job Sheet 202910

21
9-00



Part No: D2348

Job Qty: 40 pcs

Part Name: Wearplate (Key Way)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 12/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev A Removed from 9 Digit 05-12-05 JLM IPP Rev:B Now on Waterjet 06-07-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	40 pcs		12/18/19	0.01	1.49	Waterjet - Flow		on 20/03/27
120	QC 8	40 pcs		12/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
150	Outsource - 4 - Anodize	40 pcs		12/18/19			ATG001-VC	5	on 20/04/02
160	Packaging 2-1 - Receive -	40		12/18/19	0.00	0.00	Packaging 2 - 1 - B4B		

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B4B	pcs	Packaging 2 - 2 - B4B			
		Packaging 2 - 3 - B4B			
		Packaging 2 - 5 - B4B	APR 07 2020		
		Packaging 2 - 4 - B4B			
		Packaging 2 - 6 - B4B			
		Packaging 2 - 7 - B4B			
		Packaging 2 - 8 - B4B			
		Packaging 2 - 9 - B4B			
		Packaging 2 - 10 - B4B			
		Packaging 2 - 11 - B4B			
		Packaging 2 - 12 - B4B			
		Packaging 2 - 13 - B4B			
		Packaging 2 - 14 - B4B			
		Packaging 2 - 15 - B4B			
		Packaging 2 - 16 - B4B			
		Packaging 2 - 17 - B4B			
		Packaging 2 - 18 - B4B			
		Packaging 2 - 19 - B4B			
		Packaging 2 - 20 - B4B			
		Packaging 2 - 21 - B4B			
		Packaging 2 - 22 - B4B			
		Packaging 2 - 23 - B4B			
		Packaging 2 - 24 - B4B			
		Packaging 2 - 25 - B4B			
		Packaging 2 - 26 - B4B			
		Packaging 2 - 27 - B4B			
		Packaging 2 - 28 - B4B			
		Packaging 2 - 29 - B4B			
		Packaging 2 - 30 - B4B			
		Packaging 2 - 31 - B4B			
		Packaging 2 - 32 - B4B			
		Packaging 2 - 33 - B4B			
		Packaging 2 - 34 - B4B			
		Packaging 2 - 35 - B4B			
		Packaging 2 - 36 - B4B			
		170 QC 6	40 pcs	12/18/19	0.00 0.00
QC 6 - 68					
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				QC 6 - 61	
				QC 6 - 40	APR 0 9 2020
				QC 6 - 81	
180	Small Fab - 2 - B4B	40 pcs	12/18/19	0.00 1.09	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
					Small Fab - 9 - B4B
190	QC 5	40 pcs	12/18/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
200	Packaging 3-1 - Stock - B4B	40 45 pcs	12/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 -
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					B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	45	40 pcs	12/18/19	0.00 0.00	QC 21 - SA - 21 ✓	ST006
					QC 21 - SA - 70	
					QC 21 - SA - 53	DAS

Part Op 100 - 1-Cut as per Dwg D2348

Descriptions: 120 - (QC8- Inspect parts - second check)

150 - Issue P/O: 46209 Black Anodize per Dwg D2348 Rev. C

160 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certificate of conformity is attached

180 - (Small Fab) Install Insert as per Dwg D2348

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

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9-00

APR 14 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.7920 sf (.0198 ea)	100-Waterjet - Flow - 1	5227116
D3996-FE-832-EF	Self-Clinching Fastener	160 pcs (4 ea)	180-Small Fab - 2 - B4B	5231835 Y 97

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	1	430	0
180-Small Fab - 2 - B4B	D3996-FE-832-EF	160	22	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wear Plate	0.250Inches $\pm$ 0.010	0.260 0.240		
2	Wear Plate	0.648Inches $\pm$ 0.010	0.658 0.638		
3	Wear Plate	0.795Inches $\pm$ 0.005	0.800 0.790		
4	Wear Plate	2.046Inches $\pm$ 0.010	2.056 2.036		
5	Wear Plate	1.295Inches $\pm$ 0.010	1.305 1.285		
6	Wear Plate	0.656Inches + 0.005 - 0.000	0.661 0.656	Diameter	
7	Wear Plate	0.290Inches + 0.003 - 0.000	0.293 0.290	Diameter	
8	Wear Plate	0.250Inches $\pm$ 0.010	0.260 0.240	Diameter	
9	Wear Plate	0.250Inches $\pm$ 0.010	0.260 0.240		
10	Wear Plate	0.648Inches $\pm$ 0.010	0.658 0.638		
11	Wear Plate	1.546Inches $\pm$ 0.005	1.551 1.541		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S266887



Part: D2348

Job No: 202910

Serial No/Batch: S266887

Revision: Rev C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/27/20



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046209



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046209

PO Date: 4/2/20

Due Date: 4/17/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	207306	RBT18601	RBT18601 Rev 1C	Main Rotor Swashplate ReGreasing Tool -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required	Firmed	-	4/17/20	5 pcs	0 pcs	5 pcs	\$32.23/pcs	\$161.15
Line Item Note 5 kits = 10 pcs												
2	202910	D2348	D2348 Rev C	Wearplate (Key Way) : Various STC's Issue P/O: Black Anodize per Dwg D2348 Rev. C	Firmed	-	4/17/20	45 pcs	0 pcs	45 pcs	\$3.18/pcs	\$143.10
3	205685	D5230-3	D5230 Rev A	Mounting Plate : Various STC's HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK (Outsource process- Anodize per QSI017 4.1.10.1)	Firmed	-	4/17/20	6 pcs	0 pcs	6 pcs	\$8.23/pcs	\$49.38
Grand Total:												\$353.63

Guérin



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB046209



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919957

Date: 07-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
45 ea	Part: D2348 Wearplate (Key Way) Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils) Job: 27282 PO: POHB046209	Rev: C	Line: 2
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>APR 07 2020</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.

RECEIVED
APR 07 2020
DART AEROSPACE LTD.